Claims:

- 1. (Currently amended) Method for the manufacture of a ball valve (1) between two tubes (3,4), in which method the ends (7, 8) of the <u>said</u> tubes are sealed against rotatable valve balls (2) opening and closing the <u>said</u> valve, and the <u>said</u> valve ball and the <u>said</u> tube ends are surrounded by a sleeve-like cover (10) to be jointed to the mantle surfaces of the <u>said</u> tubes, characterized in that the <u>said</u> mantle of the <u>said</u> tube (3, 4) has a front face (29) formed by a beveling or stepping, narrowing it towards the <u>said</u> ends (7, 8) of the <u>said</u> tube, that the <u>said</u> sleeve-like cover (10) has an end face (22, 23) directed similarly to the <u>said</u> front face of the <u>said</u> tube, that the <u>said</u> front face of the <u>said</u> tube and the end face of the <u>said</u> cover are brought against each other, and that the <u>said</u> tube and <u>said</u> cover are jointed to each other by beam welding by directing the <u>a</u> welding beam (31) between said faces brought against each other, following their direction.
- 2. (Currently amended) Method according to Claim 1, characterized in that the <u>said</u> mantle of the <u>said</u> tube (3, 4) has turns (27, 28) on both sides of the <u>said</u> front face (29) so that the <u>said</u> welding beam penetrating the <u>a</u> joint (11, 12) formed by the opposite surfaces hits the turn and the material of the <u>said</u> tube mantle below.
- 3. (Currently amended) Method according to Claim 1 or 2, characterized in that the said beveled front face (29) of the said mantle of the said tube (3, 4) is in an angle of approximately 30-60°, preferably approximately 45° in relation to the axial direction of the said tube.
- 4. (Currently amended) Method according to one of the preceding claims, Claim 1 or 2 characterized in that it is used for the manufacture of a said ball valve with a reduced aperture (5, 6).
- 5. (Currently amended) Method according to one of the claims 1-3, Claim 1 or 2 characterized in that it is used for the manufacture of a said ball valve with a full aperture so that

the <u>said</u> mantle of the <u>said</u> tube (3, 4) has been expanded (32) and then narrowed for achieving the <u>said</u> beveled front face (29) for jointing the <u>said</u> sleeve-like cover (10).

- 6. (Currently amended) Method according to one of the preceding claims, Claim 5 characterized in that the said cover (10) is attached to the said mantle of the said tube (3, 4) by laser welding (30, 31).
- 7. (Currently amended) Method according to one of the claims 1-5, Claim 5 characterized in that the said cover (10) is attached to the said mantle of the said tube (3, 4) by electron beam welding.
- 8. (Currently amended) Method according to one of the preceding claims, Claims 1 or 2 characterized in that an aperture (20) is provided to the <u>said</u> cover (10), to which aperture the <u>a</u> spindle (13) rotating the <u>said</u> valve ball (2) and the <u>a</u> surrounding support sleeve (14) are fitted, the <u>vale ball (2) and the said surrounding support sleeve (14) are fitted</u>, the <u>said</u> support sleeve being jointed to the <u>an</u> edge (21) of the <u>said</u> aperture by beam welding.
- 9. (Currently amended) Method according to Claim 8, characterized in that the <u>said</u> cover (10) is shaped so that the <u>an</u> edge (21) of the <u>said</u> aperture (20) is located in one plane parallel to the axis of the said tubes (3, 4).
- 10. (Currently amended) Method according to Claim 9, characterized in that the mating faces (21, 26) of the <u>said</u> edge (21) of the <u>said</u> aperture (20) and the <u>said</u> support sleeve (14) of the <u>said</u> spindle, which are jointed together by beam welding, are in an angle of 30-60°, preferably approximately 45° in relation to the axial direction of the <u>said</u> tubes (3, 4).
- 11. (Currently amended) The use of beam welding, such as laser or electron beam welding in the assembly of a ball valve (1) when attaching the <u>a</u> sleeve-like cover (10) surrounding the <u>a</u> valve ball (2) and the said ends (7, 8) of the <u>said</u> tubes (3, 4) sealed against it

from its said ends (22, 23) to the said flanks of the tubes.

12. (Currently amended) The use of beam welding, such as laser or electron beam welding in the assembly of a ball valve when attaching the <u>a</u> support sleeve (14) of the <u>a</u> spindle rotating the <u>a</u> valve ball (2) to the <u>an</u> aperture (20) made to the <u>a</u> sleeve-like cover (10) surrounding the <u>said</u> valve ball and the <u>having</u> ends (7, 8) of the <u>said</u> tubes (3, 4) sealed against it.